

Work Order ID 163486

Tuesday, June 27, 2017 1:22:12 PM

163486

Page 1

Item ID: D4017-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Short Basket Base Assembly (350)
Start Date: 6/27/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/11/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DAS Date: JUN 28 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4017	F								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: B38057 0.00***100***

Large Fab

Large Fab

Memo

2.77

1- assemble ribs , weld as per dwg D4017 using DT9610B
inspect before welding mesh

2- Cut mesh as per dwg D4020-3

3- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends

4- weld hinge (3) and Mounting brackets as per dwg D4017
take lid to locate hinge and bracket

5- Weld D4672-3 blanking plates as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

1x 67 17-07-200 17.07.24DAS
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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120	QC5- Inspect part completeness to step on W/O	0.00							
120									DAS
QC	Memo	0.02							9
Quality Control	-Scribe Dart P/N and B/N as per dwg. Using 0.13 (minimum) high lettering per QSI 044 6.4								9-89
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.36							
Hand Finishing									

① 17.07.24
1 Ø 17-07-27 83438

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130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M 138014</i> Memo 1- Plug holes and mask only interior of hinge (3) prior to powder coat 2--Mask this area prior to finish View G-G 1ST COAT: START TIME: <i>2:30</i> OVEN TEMPERATURE: <i>375°</i> FINISH TIME: <i>2:45</i> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.52				<i>1</i>	<i>0</i>	<i>1707-27</i>	<i>2300</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01						<i>1 x c</i>	<i>12/07/28</i>

DAS
15
9-89

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Assemble as per dwg	0.00							
150									
HandFinish	Memo	0.63							
Hand Finishing									
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.02							
Quality Control									
170	Identify as per dwg & Stock Location: <u>W/O</u>	0.00							
170									
Packaging	Memo	0.01							
Packaging									

D 4032-041 / B163533

JUL 28 2017

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.10							
Quality Control									

**DAS
21
9-89**

AUG 01 2017

DQA: _____ Date: _____



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Picklist Print

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Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC IPP REV:F 12.07.24 AS PER DWG REV.D DD VERF:EC IPP REV:G 13.08.21 DWG REV.E / ECN 13-624 DD VERF:JLM IPP Rev.H 17.06.12 As per Dwg. Rev.F DP Verify DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4672-3		Manufactured	No			100	Each	18.0000	2	2			

D4672-3

Blanking Plate

**

B157868 → 2. Cg 17-07-06

Location

Loc Qty

Loc Code

WA004

18

157868

18

M304EX0.75-16F

Purchased

No

100

sf

573.0000

19.1516

19.1516

M304FX0 75-16F

Expanded Metal Flat SS

**

B137765 → 25 Cg 17-07-06

Location

Loc Qty

Loc Code

WA004

573

M137294

93

M137765

480

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Page 2

Work Order ID: 163486

163486

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 6/27/2017

Required Date: 7/11/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

150

Each

2,530.000

2

2

NAS1149FN832P

Washer

**

DAS

6
9-89

JUL 25 2017

Location

Loc Qty

Loc Code

GA

358

M135058

208

M136182

40

M136866

110

ST260a

1500

M137820

1500

ST263

672

M137412

672

2

D4017-1

Manufactured

No

100

Each

4.0000

1

1

D4017-1

Rib

**

B148052 1x 17-07-06

Location

Loc Qty

Loc Code

WA004

4

148052

4

D4017-3

Manufactured

No

100

Each

6.0000

1

1

D4017-3

Rib

**

B160505 1x 17-07-06

Location

Loc Qty

Loc Code

WA004

6

160505

6

D4017-5

Manufactured

No

100

Each

2.0000

1

1

D4017-5

Hinge Rib

**

B157843 1x 17-07-06

Location

Loc Qty

Loc Code

WA004

2

157843

2

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Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 3

Work Order ID: 163486

163486

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 6/27/2017

Required Date: 7/11/2017

Start Qty: 1.00

Required Qty: 1.00

D4017-7 Manufactured No

100 Each 29.0000 3 3

D4017-7

Rib

**

B161933 → 30 Cg 17-07-06

Location	Loc Qty	Loc Code
WA004	29	
161932	10	
161933	9	
161934	10	

D4017-9 Manufactured No

100 Each 8.0000 2 2

D4017-9

Rib

**

B161505 → 2 Cg 17-07-06

Location	Loc Qty	Loc Code
WA004	8	
161509	8	

D3916-041 Manufactured No

100 Each 6.0000 2 2

D3916-041

Rib Assembly

**

B161896 → 2 Cg 17-07-06

Location	Loc Qty	Loc Code
WA004	6	
161896	6	

D3916-5 Manufactured No

100 Each 0.0000 1 1

D3916-5

Light Rib

**

B163458 → 1 Cg 17-07-06

D4034-041 Manufactured No

100 Each 1.0000 1 1

D4034-041

Aft Upper Rib Assembly

**

B163305 → 1 Cg 17-07-06

Location	Loc Qty	Loc Code
WA004	1	
162680	1	

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

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Work Order ID: 163486

163486

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 6/27/2017

Required Date: 7/11/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D4034-043
D4034-043
Fwd Upper Rib Assembly

Manufactured No

100 Each 3.0000 1 1

**

B162681 → AC 1707-06

Location Loc Qty Loc Code

WA004 3

162681 3

✓ D2581
D2581
Mounting Bracket

Manufactured No

100 Each 30.0000 2 2

**

B161800 → 2 C 1707-06

Location Loc Qty Loc Code

WA004 30

161800 30

✓ D3913-15
D3913-15
Wide Handle Plate

Manufactured No

100 Each 35.0000 1 1

**

B161938 → 1 C 1707-06

Location Loc Qty Loc Code

WA004 35

161938 35

✓ D4016-1
D4016-1
Hinge Half, Base

Manufactured No

100 Each 85.0000 3 3

**

B159537 → 3 C

Location Loc Qty Loc Code

WA004 85

158630 3

159537 82

~~1707-06~~
1707-06

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Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Work Order ID: 163486

163486

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 6/27/2017

Required Date: 7/11/2017

Start Qty: 1.00

Required Qty: 1.00

D4020-11

Manufactured No

100

Each

13.0000

2

2

D4020-11

End Mesh, Basket

**

B162864 → 2₂ C₁₇₀₇₋₀₆

Location

Loc Qty

Loc Code

WA004

3

161475

3

WA006

10

162864

10

D4021-1

Manufactured No

100

Each

50.0000

3

3

D4021-1

Handle Plate

**

B161473 → 3₂ C₁₇₀₇₋₀₆

Location

Loc Qty

Loc Code

WA004

50

161473

20

161900

30

D2931

Manufactured No

150

Each

1,284.000

2

2

D2931

Bumper

**

DAS

6

9-89

JUL 25 2017

Location

Loc Qty

Loc Code

ST013

184

86435

184

ST025A

1100

86435

1100

D4021-5

Manufactured No

150

Each

13.0000

2

2

D4021-5

Blanking Plate

**

DAS

6

9-89

JUL 25 2017

Location

Loc Qty

Loc Code

ST068

13

161816

13

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Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 6

Work Order ID: 163486

163486

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 6/27/2017

Required Date: 7/11/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No

150 Each 112.0000 6 6

AN3-10A

Bolt

**

DAS

6

9-89

JUL 25 2017

Location

Loc Qty

Loc Code

GA 39

m136787 39

ST349 73

m137321 4

m137544 69

MS20600-AD4W3 Purchased No

150 Each 458.0000 2 2

MS20600-AD4W3

Cherry Rivet

**

DAS

6

9-89

JUL 25 2017

Location

Loc Qty

Loc Code

CCK004 300

m137412 300

ST308 98

m135603 98

WA003 60

m136648 60

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Work Order ID: 163486

163486

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 6/27/2017

Required Date: 7/11/2017

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,467.000

6

6

MS21042L3

**

DAS

Nut

6

8-89

Location

Loc Qty

Loc Code

FP001

79

m135945

79

GA

394

m134360

102

M136665

292

OVER007

500

m134360

0

m137886

500

ST303

494

m137680

494

NAS1149F0332P

Purchased

No

150

Each

2,236.000

12

12

NAS1149F0332P

**

DAS

Washer

6

9-89

Location

Loc Qty

Loc Code

GA

275

m133709

275

ST262

1961

m137710

1961

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

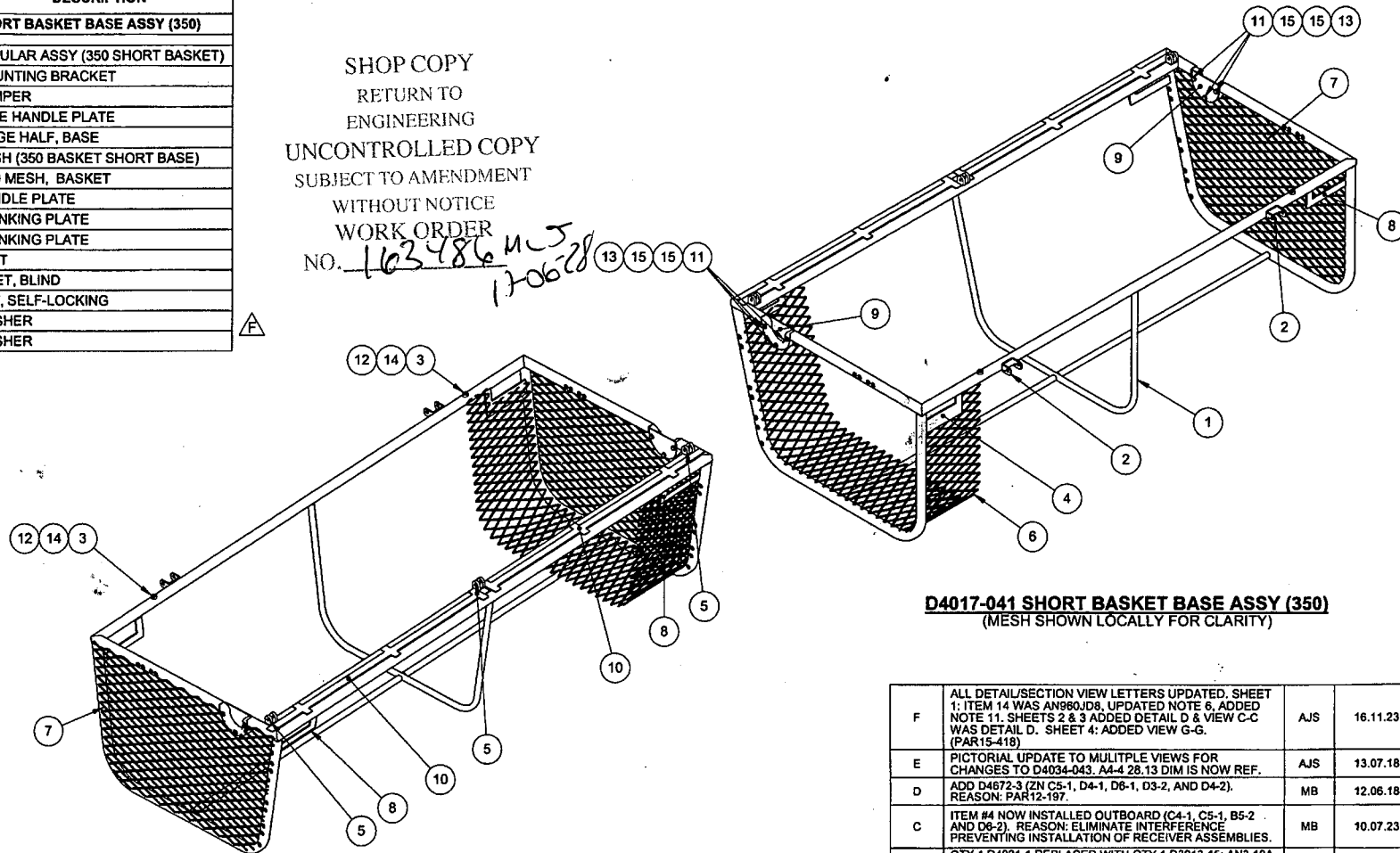
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

ITEM	QTY	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-3	BLANKING PLATE
11	6	AN3-10A	BOLT
12	2	MS20600AD4W3	RIVET, BLIND
13	6	MS21042L3	NUT, SELF-LOCKING
14	2	NAS1149FN832P	WASHER
15	12	NAS1149F0332P	WASHER

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163486 MJS
170628



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

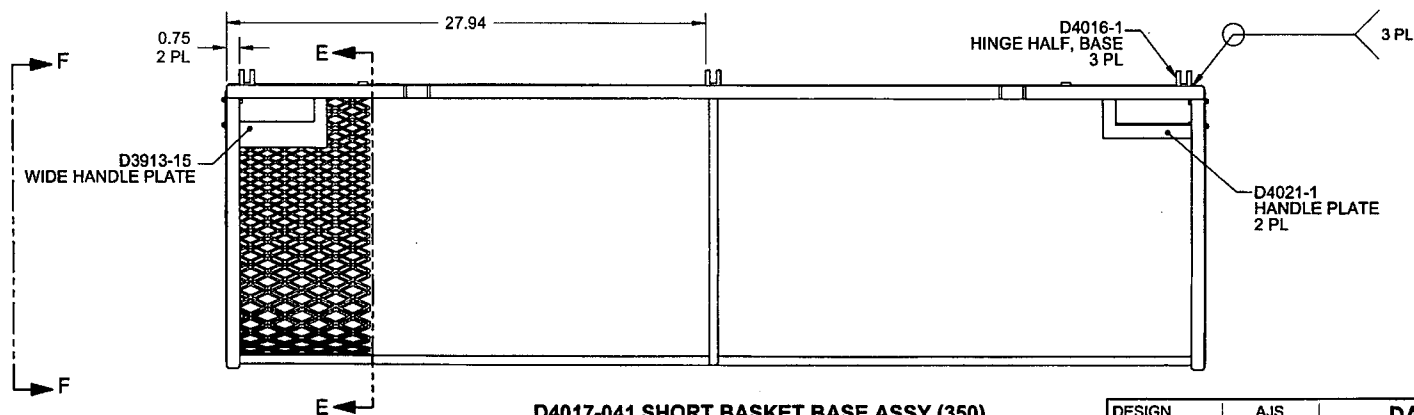
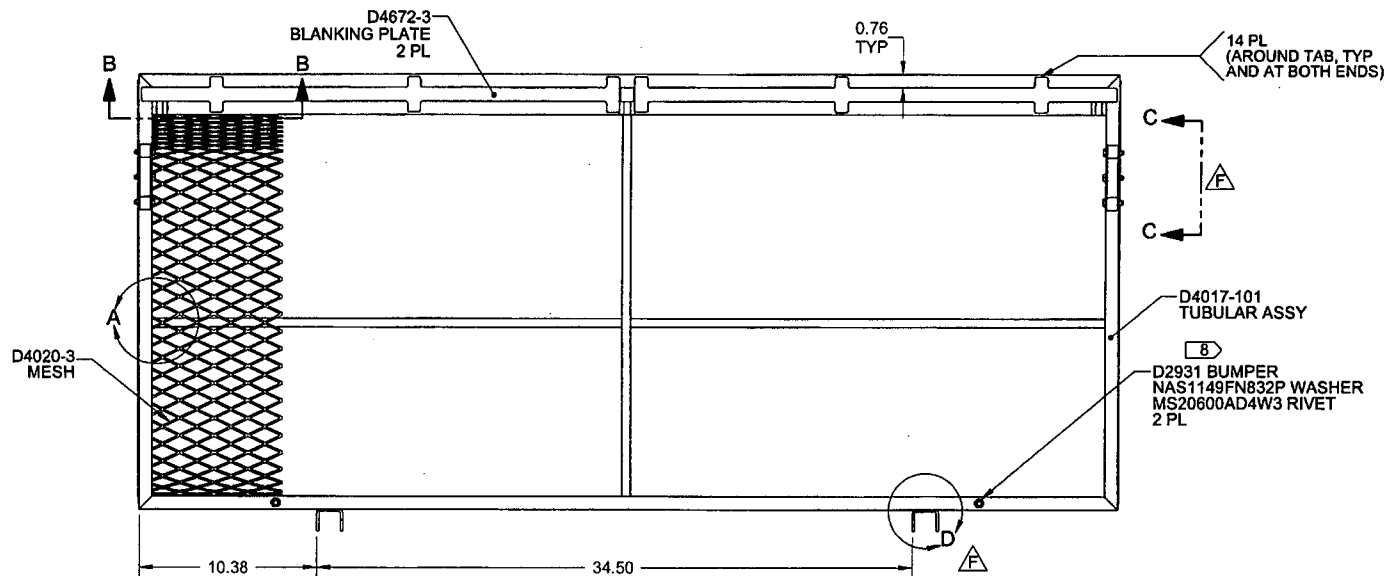
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART P/N AND B/N USING 0.13 (MINIMUM) HIGH LETTERING PER QSI 044 6.4
- 7) WEIGHT: 30.0 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004
- 11) MASK THIS AREA PRIOR TO FINISH

F	ALL DETAIL/SECTION VIEW LETTERS UPDATED. SHEET 1: ITEM 14 WAS AN980JDB. UPDATED NOTE 6. ADDED NOTE 11. SHEETS 2 & 3 ADDED DETAIL D & VIEW C-C WAS DETAIL D. SHEET 4: ADDED VIEW G-G. (PAR15-418)	AJS	16.11.23
E	PICTORIAL UPDATE TO MULTIPLE VIEWS FOR CHANGES TO D4034-043. A4-4 28.13 DIM IS NOW REF.	AJS	13.07.18
D	ADD D4672-3 (ZN C5-1, D4-1, D6-1, D3-2, AND D4-2). REASON: PAR12-197.	MB	12.06.18
C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C032R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4017 SHORT BASKET BASE ASSY (350) COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AJS		
CHECKED	JMH		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS	REV. F	
DATE	16.11.23	SHEET 1 OF 6	
		SCALE	
		NTS	

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2017-06-07
EON 17-580

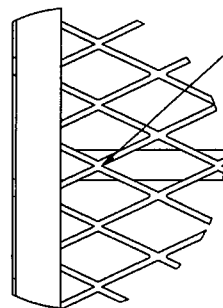


D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

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2017-06-07

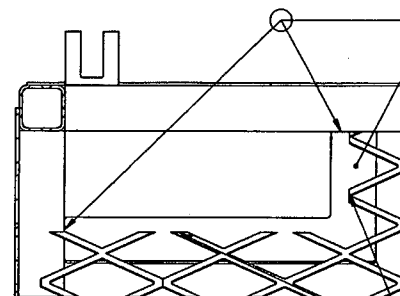
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DRAWN	AJS		
CHECKED	JMH	DRAWING NO.	REV. F
MFG. APPR.	DD	D4017	SHEET 2 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SHORT BASKET BASE ASSY (350)	NTS
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TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

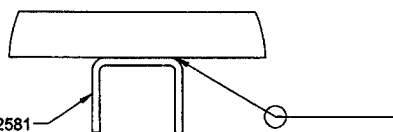
DETAIL A
SCALE 2X



D4021-1
HANDLE PLATE

SECTION B-B
TYPICAL FOR ALL
HANDLE PLATES

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION



D2581
MOUNTING BRACKET

DETAIL D 
2 PL

 D4021-5
BLANKING PLATE

 AN3-10A BOLT
NAS1149F0332P WASHER, QTY (2)
MS21042L3 NUT
3 PL

TRIM MESH LOCALLY
0.50 - 0.60
TO CLEAR FASTENERS

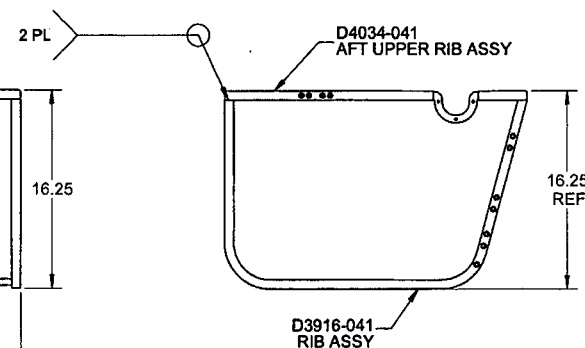
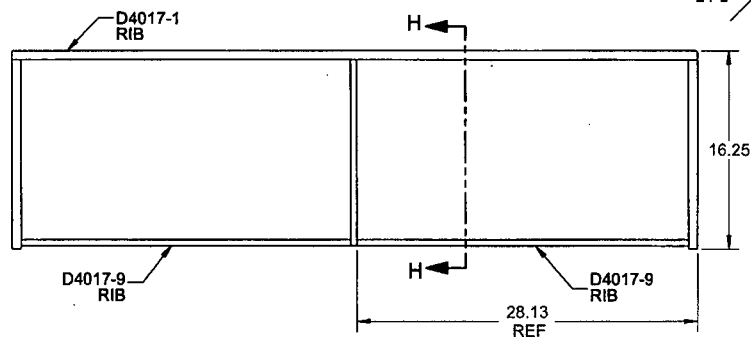
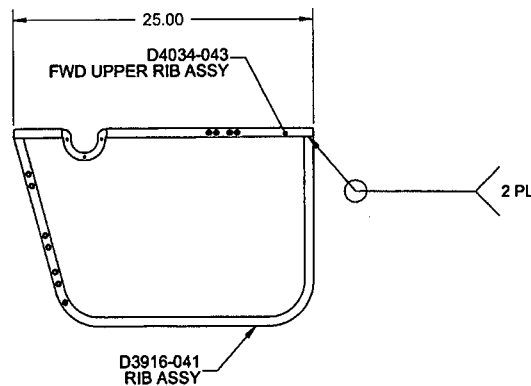
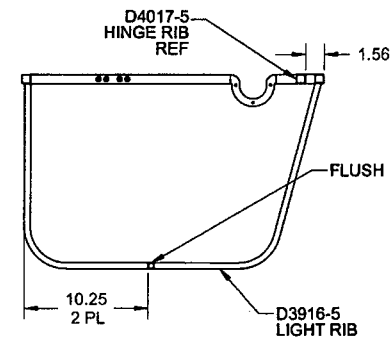
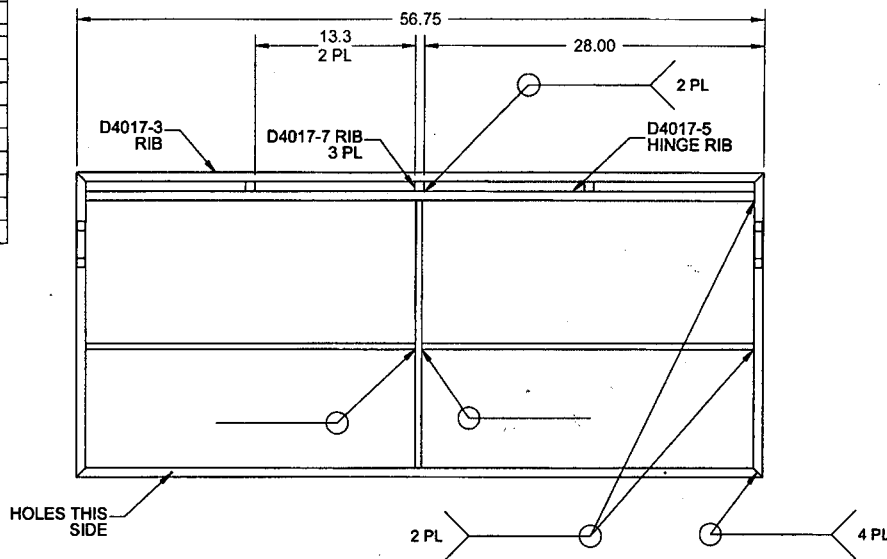
VIEW C-C
2 PL

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2017-06-07

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DRAWN	AJS		
CHECKED	JMH	DRAWING NO. D4017	REV. F
MFG. APPR.	DD		SHEET 3 OF 6
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	SHORT BASKET BASE ASSY (350)	NTS
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	3	D4017-7	RIB
5	2	D4017-9	RIB
6	1	D3916-5	LIGHT RIB
7	2	D3916-041	RIB ASSY
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.38 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

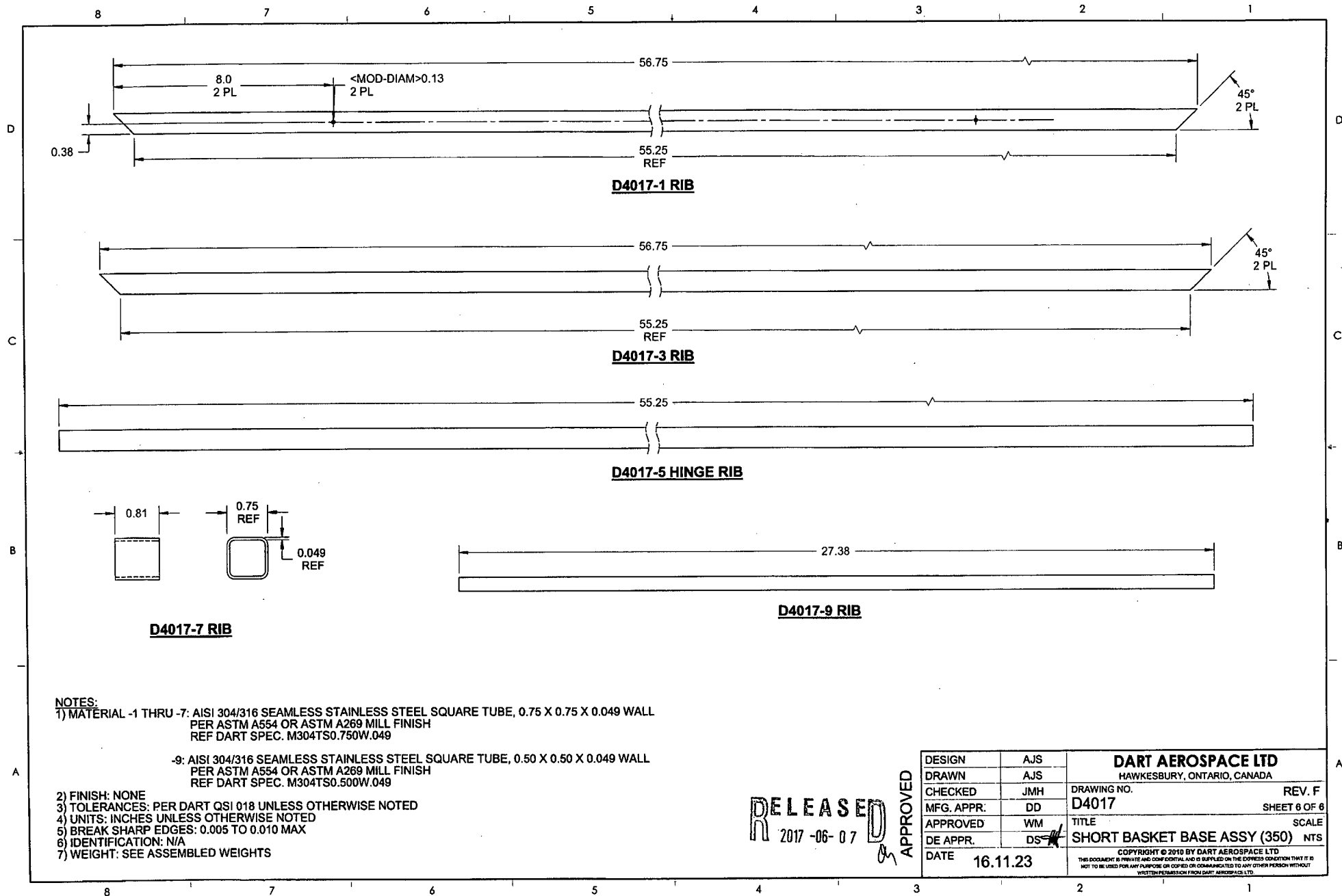
8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

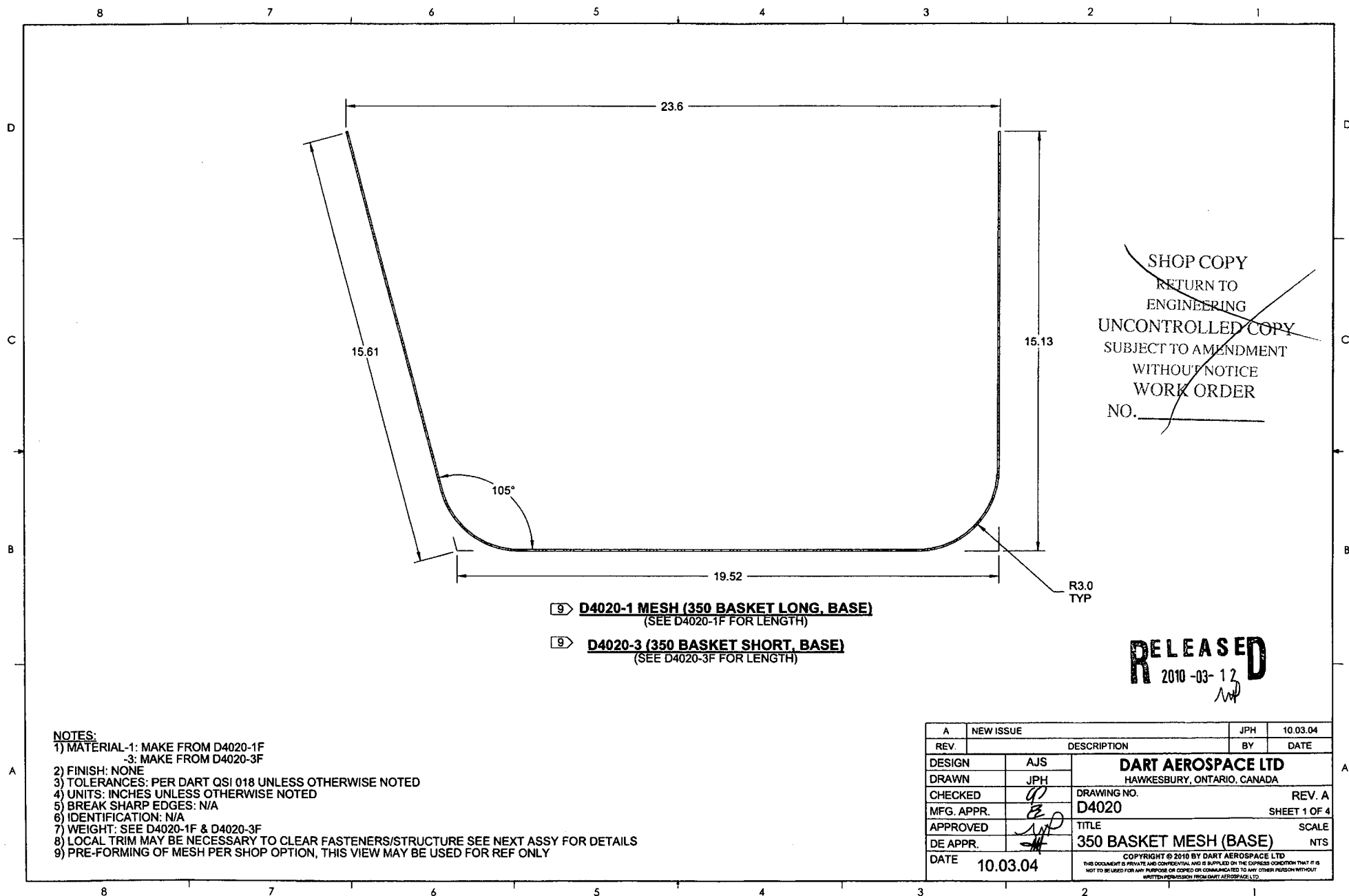
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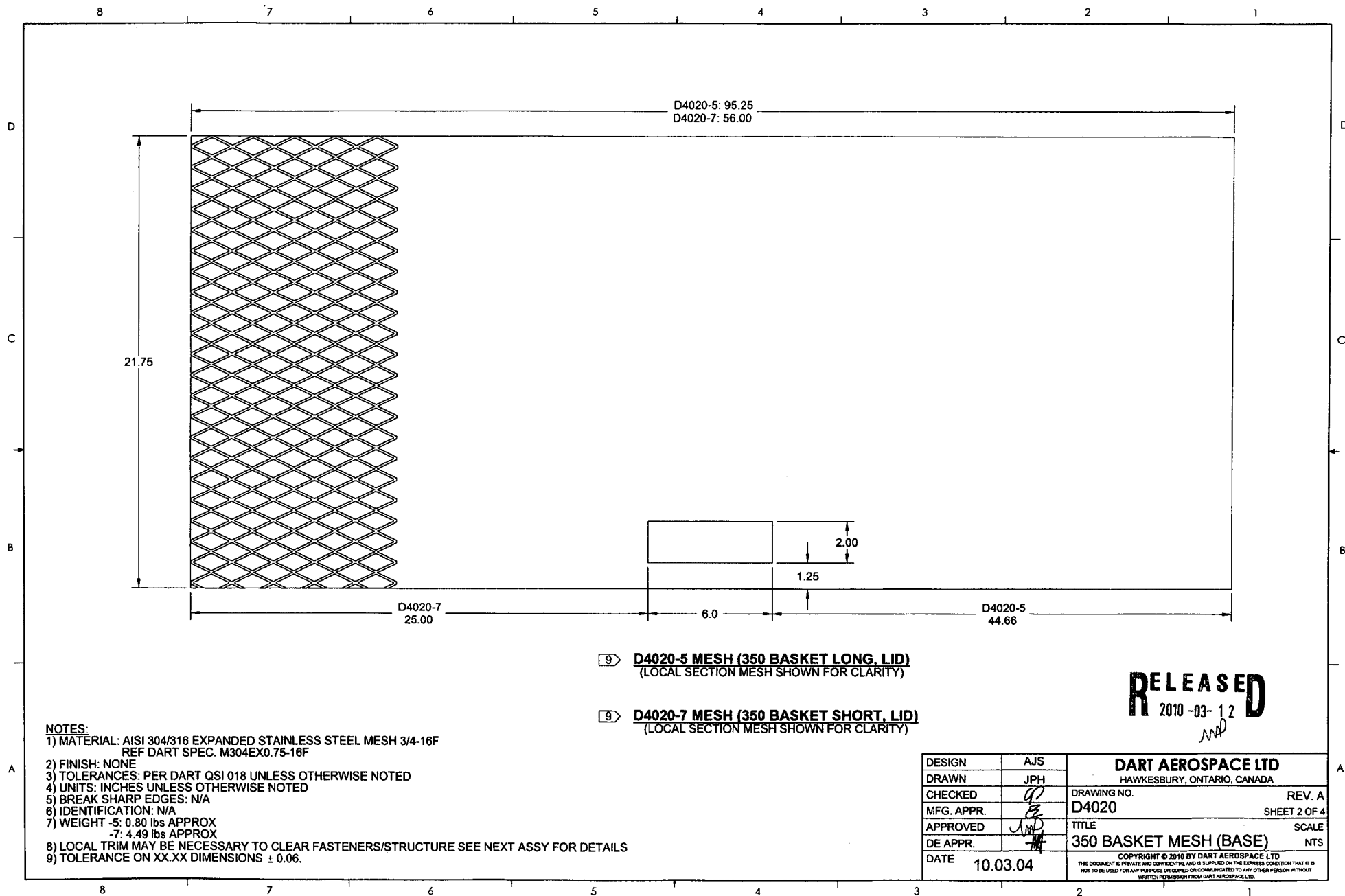
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DESIGN	AJS
DRAWN	AJS
CHECKED	JMH
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	16.11.23

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4017	REV. F
TITLE SHORT BASKET BASE ASSY (350)	SCALE NTS
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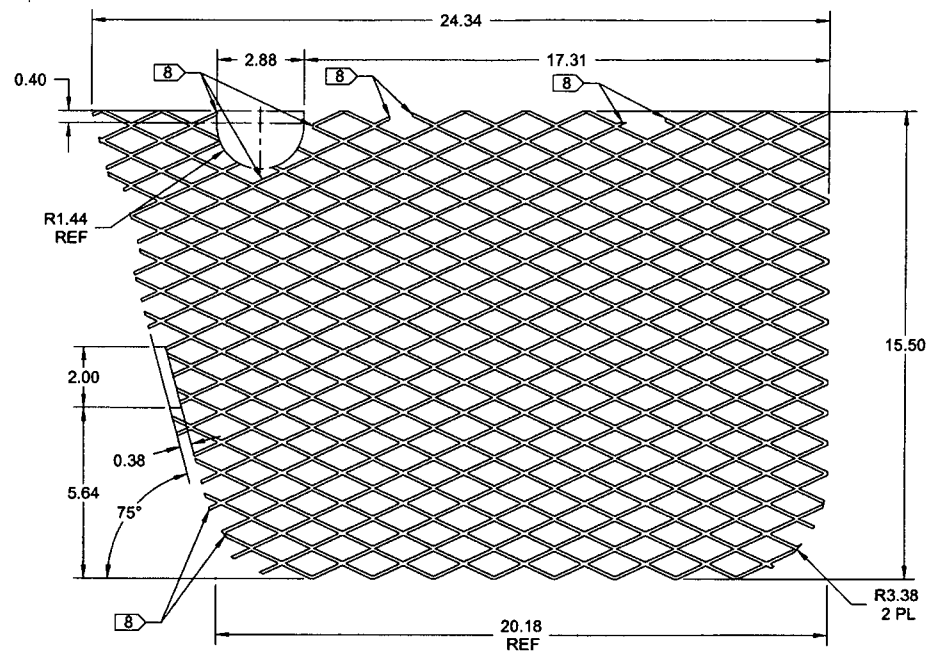






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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	<i>[Signature]</i>	DRAWING NO. D4020	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 BASKET MESH (BASE)	NTS
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9 D4020-11 END MESH, BASKET

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

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MFG. APPR.	<i>[Signature]</i>	D4020	SHEET 3 OF 4
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